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D3913-041
Job Sheet 197741



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/12/19

Created By: Manon Dubois

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV:B DD VERF:EC IPP REV:D 13.08.21 DWG REV:C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	8/12/19		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		MAL
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	8/12/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	1 pcs	8/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS
							QC 5 - 43		43
							QC 5 - 49		9-89
							QC 5 - 51		
							QC 5 - 58		

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	8/12/19	0.00	0.29	Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	BEB19-08-12
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	8/12/19	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	BEB19-08-12
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	8/12/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	UL 19-8-13
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	8/12/19	0.00	0.50	Handfinish - 4 - 1 - B4B	UL 19-8-13
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	

DAS
15
9-89

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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	8/12/19	0.00	0.00	QC 21 - SA - 21	D48
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	9-18

AUG 13 2019

Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

S193459

START: 2:10 TEMP: 325° FINISH: 2:25

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S188 852
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S190938
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S184576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S189078
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S179660
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S190822
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	S193331
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S194468
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	S188922
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S183658
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S184582
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S190040
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	S192406
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S192071
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S197252
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	S184347
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	S188431
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S179612-2
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S802551
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S199496
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	S152976
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S188980
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S136362

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	36	0
	D3913-1	1	8	0
	D3913-15	1	22	0
	D3913-3	1	8	0
	D3913-7	2	18	0
	D3913-9	1	11	0
	D3916-041	2	6	0
	D3916-5	3	14	0
	D4016-1	3	34	0
	D4017-7	3	46	0
	D4017-9	2	16	0
	D4020-11	2	10	0
	D4021-1	3	34	0
	D4034-041	1	4	0
	D4034-043	1	10	0
	D4672-1	2	11	0
	M304EX0.75-16F	32	625	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	179	0
	D2931	2	691	0
	D4021-5	2	34	0
	MS20600-AD4W3	2	932	0
	MS21042L3	6	1,073	0
	NAS1149F0332P	12	2,464	0
	NAS1149FN832P	2	2,070	0
Part Specifications				
Specifications could not be found.				

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Container No: S204249



Part: D3913-041

Job No: 197741

Serial No/Batch: S204249

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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